



ASSEMBLY PROCEDURES.

- 1) ASSEMBLE ITEMS #1, 2, 3 AND 5 BEFORE INSTALLATION.
- 2) LAY-IN ITEM #18 BOTTOM LINER TO BE RESTING PAD OF ITEM # 13
(Ø4-20) SET SCREWS OF THE BASE PLATE INSIDE OF THE CAVITY.
- 3) INSTALL PARTIALLY ASSEMBLED (ITEMS #1, 2, 3, 5 WITH ALL SET SCREWS) INSIDE OF THE CAVITY.
- 4) THE BASE PLATE SHALL BE ADJUSTED TO THE PROPER HEIGHTS AS SHOWN DWG. K1-430000-01, (-.030)
AND THE SET SCREWS MUST BE LOWER BY AT LEAST 1/8" FROM THE TOP OF BASE PLATE,
- ROOM FOR LOCK SET (ITEM #16). USED THE WRIGHT SIZE OF SET SCREW AS NEEDED
- USED ITEM #11 FOR FILLING THE GAP RE-CUT IF NEEDED.
- USED YOUR JUDGEMENT AS PER FIELD CONDITIONS.
- 5) BOTH SIDES PLATE SHALL BE ALIGNED AND PARALLEL TO THE CTR. OF BEAM LINE, (-.030)
USING THE SIDES SET SCREWS FOR ADJUSTMENTS, TO BE RESTED IN ITEM #19 SIDES LINER.
- USED THE WRIGHT SIZES OF SET SCREW AS NEEDED.
- USED ITEM #11 FOR FILLING THE GAP RE-CUT IF NEEDED.
- 6) RECHECK THE BASE PLATE POSITION, IF MOVED OR MISALIGNED REPEAT STEP #4 AND #5,
OTHERWISE CONTINUE TO STEP #7.
- 7) TIGHTEN THE (4) FOUR SET SCREWS (ITEM #14) ON THE TOP OF SIDES PLATE TO LOCKED.
- 8) INSTALL (3) THREE LOCK SET (ITEM #16) TO THE BASE PLATE TO LOCKED.
- 9) STOP SEE DWG K1-430000-00.
- 10) INSTALL AND ASSEMBLE INPLACE THE LEAD (ITEM # 7 TO #11)
- 11) INSTALL THE RETAINER PLATE (ITEM #6) AND THE FRONT END PLATE (ITEM #4) WITH
(8) EIGHT SET SCREWS (ITEM #15) TO SECURED LEAD IN PLACE.

NOTE:

1- LEAD LINED PANELS SHALL BE CONSTRUCTED FROM SINGLE UNPIERCED SHEET. FREE OF OXIDE INCLUSIONS, FISSURES, VOIDS AND ALL OTHER DETRIMENTAL DEFECTS. MATERIAL SHALL BE LEAD GRADE "C" TO COMPLY WITH FEDERAL SPECIFICATION - QQL201. HUTCH SHALL MEET ALL APPLICABLE FEDERAL, STATE AND LOCAL RADIATION GUIDE LINES: NBS HANDBOOK 111 AND 114, ANSI N43.2 AND DOE ORDER 5480.11

2- ALL DIMENSIONS SHOWN IN [] ARE MILLIMETERS AND FOR REFERENCE USE ONLY.

ITEM	QUANTITY	DESCRIPTION	MATERIAL & SPEC	REV
K1430612-00	18	K1-430612-00	K1-43 FOE WALL COLL. LINER PLATE	3
	16	Ø4-20 x 1/8" LG. HOLLOW LOCK SCREW	ALLOY STEEL	3
	15	#8-32 x 5/8" LG. FLAT PT. SET SCREW	STAINLESS STEEL	8
	14	#8-32 x 1/2" LG. FLAT PT. SET SCREW	STAINLESS STEEL	4
	13	Ø4-20 x 3/8" LG. FLAT PT. SET SCREW	STAINLESS STEEL	11
	12	#10-24 x 1/2" LG. SOCKET HD SCREW	STAINLESS STEEL	30
K1430611-01	11	K1-430611-01	K1-43 FOE WALL COLL. LEAD TOP & SHIMPLATE	1
K1430609-01	9	K1-430609-01	K1-43 FOE WALL COLL. LEAD UPPER MID. PLATE	20
K1430608-01	8	K1-430608-01	K1-43 FOE WALL COLL. LEAD LOWER MID. PLATE	10
K1430607-01	7	K1-430607-01	K1-43 FOE WALL COLL. LEAD PLATE	10
K1430606-01	6	K1-430606-01	K1-43 FOE WALL COLLIMATOR RETAINER PLATE	1
K1430605-01	5	K1-430605-01	K1-43 FOE WALL COLLIMATOR BACK PLATE	1
K1430604-01	4	K1-430604-01	K1-43 FOE WALL COLLIMATOR FRONT PLATE	1
K1430602-01	3	K1-430602-01	K1-43 FOE WALL COLLIMATOR SIDE PLATE	1
K1430602-01	2	K1-430602-01	K1-43 FOE WALL COLLIMATOR SIDE PLATE	1
K1430601-01	1	K1-430601-01	K1-43 FOE WALL COLLIMATOR BASE PLATE	1

ITEM	QUANTITY	DESCRIPTION	MATERIAL & SPEC	REV
K1430600-01-01	1	K1430600-01-01	K1-43 4ID WALL COLLIMATOR FOE LEAD ASSEMBLY	1

DATE	BY	CHKD	APPD	DESCRIPTION
8/19/98	J. CHANG	8/19/98	A. CORCUERA	DESIGN
9/25/98	J. CHANG	9/25/98	A. CORCUERA	DESIGN
9/27/98	D. SHU	9/27/98	A. CORCUERA	DESIGN
9/29/98	T. KUZAY	9/29/98	A. CORCUERA	DESIGN
9/29/98	T. KUZAY	9/29/98	A. CORCUERA	DESIGN
9/29/98	T. KUZAY	9/29/98	A. CORCUERA	DESIGN

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